

Work Order ID 86033-2 Spt. + 2/2

\*86033\*

June-19-12 4:07:23 PM

Page 1

Item ID: D3463-042

Accept

Revision ID:

\*N9000040100\*

Setup Start

\*NS1\*

Item Name: Step Weldment Assembly

Stop

\*NS2\*

Start Date: 19/06/2012 Start Qty: 4.00

\*4\*

Required Date: 03/07/2012 Req'd Qty: 4.00

\*4\*

2

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 12/06/20

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100

0.00

\*100\*

Large Fab

Large Fab

Memo

M122357

0.00

Large Fab

Weld assembly as per dwg D3463 using DT8875

2

13-06-05  
JH

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

2

0

13-06-06

DAS  
09  
2-89

DAS  
18  
8-89

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

2

13-06-05

DAS  
09  
2-89

# Work Order ID 86033

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Page 2

Item ID: D3463-042 Accept

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 19/06/2012 Start Qty: 4.00 \*4\*

Required Date: 03/07/2012 Req'd Qty: 4.00 \*4\*

Reference:

Approvals: Process Plan: Date: Tooling:

QC: Date: SPC (Y/N):

\*N9000040100\* Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00

\*130\*

Powdercoat

Powder Coating

Memo

1- Mask areas indicated on dwg D3463 (holes, threads)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

1:20

400 OF

1:50

M12534

140

\*140\*

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

Memo

0.00

150

\*150\*

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

2x p m/f 13/06/06

2 p BK 13-6-7.

2x p M 13/06/07



# Work Order ID 86033

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Item ID: D3463-042  
 Revision ID:  
 Item Name: Step Weldment Assembly  
 Start Date: 19/06/2012 Start Qty: 4.00  
 Required Date: 03/07/2012 Req'd Qty: 4.00  
 Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*  
 Stop \*NS2\*

Cust Item ID:  
 Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
160	Identify as per dwg & Stock Location: <i>GA</i>	0.00
*160*		
Packaging	Memo <i>w/o 100929</i>	0.00
Packaging		
170	QC21- Final Inspection - Work Order Release	0.00
*170*		
QC	Memo	0.00
Quality Control		

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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*2x*

*SP 3/06/12*

*13/6/13*

*PLB-04-13*

# Picklist Print

June-19-12 4:07:29 PM

Page 1

Work Order ID: 86033

\*86033\*

Parent Item: D3463-042

\*D3463-042\*

Parent Item Name: Step Weldment Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.18 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806 *238-806* SS DOWEL PIN 1" LONG		Purchased	No			100	Each	116.0000	2	8			

\*\*

13-05-08  
JBL

## Location

## Loc Qty

## Loc Code

ST399

16

117606

16

ST400

100

120119

100

D3453-3

Manufactured No

\*D3453-3\*

Clevis

100

Each

28.0000

1

4

\*\*

13-05-08  
JBL

## Location

## Loc Qty

## Loc Code

WA

20

83437

20

WA022

8

78209

8

D3453-5

Manufactured No

\*D3453-5\*

Plug

100

Each

27.0000

1

4

\*\*

13-05-08  
JBL

## Location

## Loc Qty

## Loc Code

WA

27

59204

0

78210

3

83438

24

42

# Picklist Print

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Page 2

Work Order ID: 86033

\*86033\*

Parent Item: D3463-042

\*D3463-042\*

Parent Item Name: Step Weldment Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3463-1 Manufactured No

\*D3463-1\*

Arm

100 Each 10.0000 1 4

\*\*

13-05-08  
JSC

## Location

LG 89292  
83439  
WA 80860  
82313

## Loc Qty

6  
6  
4  
4

## Loc Code

2

D3463-3 Manufactured No

\*D3463-3\*

Step

100 Each 12.0000 1 4

\*\*

13-05-08  
JSC

## Location

WA 86814  
78886  
83440  
WA023 88399  
78212

## Loc Qty

20  
2  
6  
-8  
4

## Loc Code

1

D3463-5 Manufactured No

\*D3463-5\*

End Cap

100 Each 33.0000 2 8

\*\*

13-05-08  
JSC

## Location

WA004 89329  
78213  
WA023  
78838

## Loc Qty

3  
3  
30  
30

## Loc Code

84

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Shop Packet Print

Page 2



# Picklist Print

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Work Order ID: 86033

\*86033\*

Parent Item: D3463-042

\*D3463-042\*

Parent Item Name: Step Weldment Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3463-7

Manufactured No

100

Each

8.0000

1

4

\*D3463-7\*

\*\*

Drag Arm

13-06-05  
~~13-06-08~~  
JBL

## Location

WA

~~88429~~

82308

WA025

~~97185~~

78202

97188

## Loc Qty

16

6

-8

2

## Loc Code

~~4~~

~~4~~

2

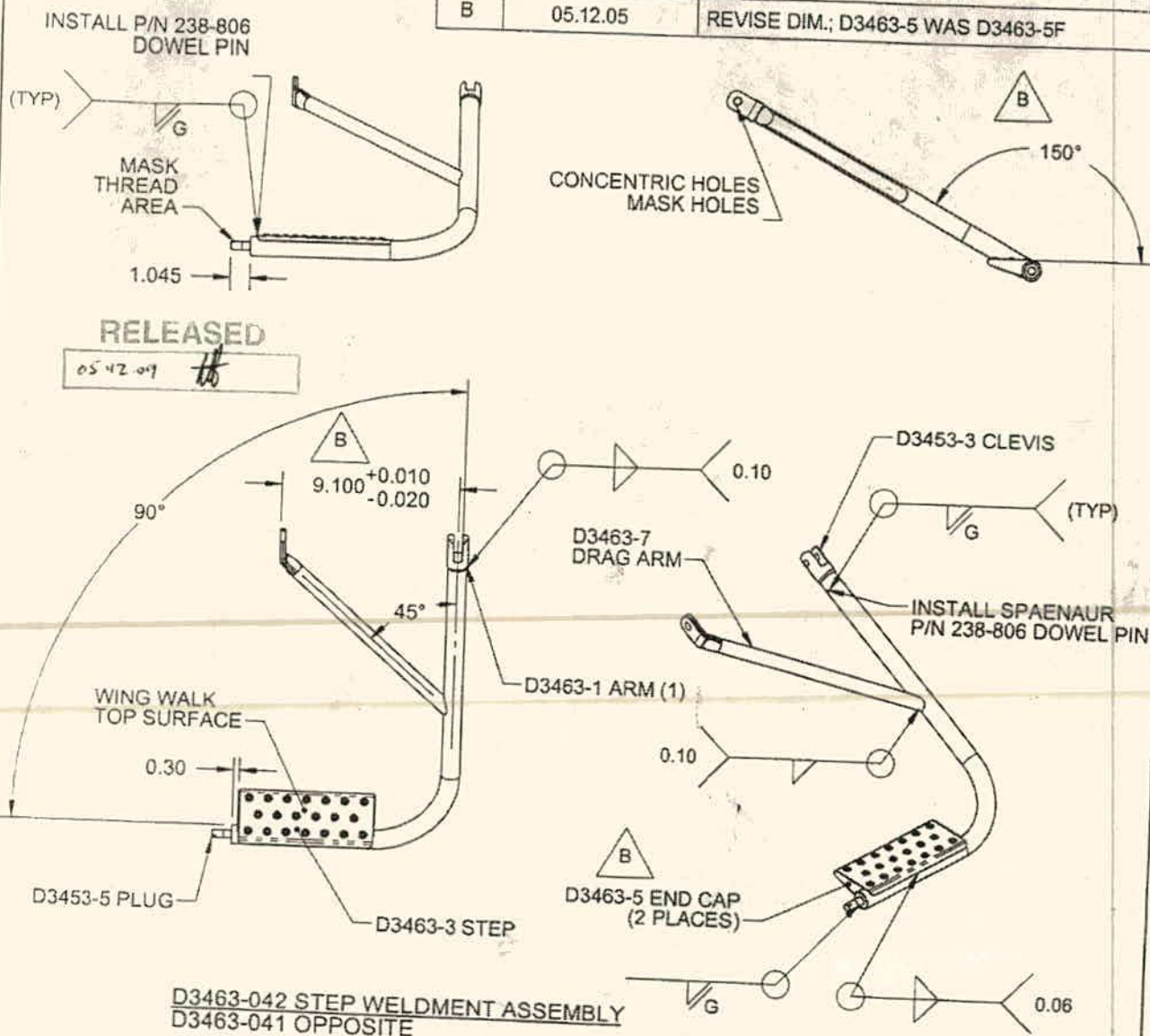
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Shop Packet Print

Page 3

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B
DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SHEET 1 OF 4
A	05.09.20	NEW ISSUE	SCALE 1:8
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER  
NO. 81005345  
12/06/20

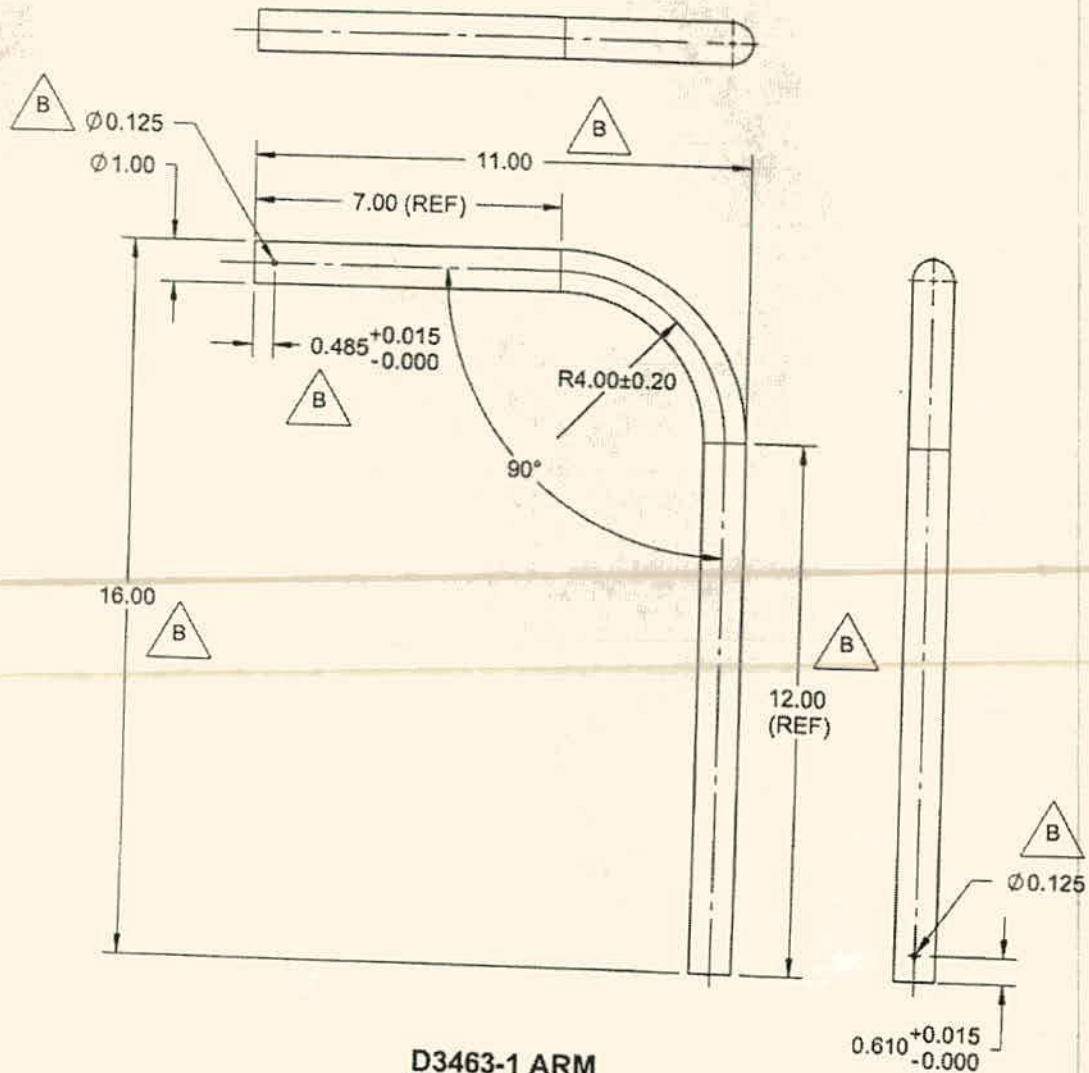
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**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B
DATE 05.12.05		TITLE STEP WELDMENT	SHEET 2 OF 4
			SCALE 1:4

RELEASED

05.12.05 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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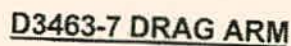
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86033





05.12.04



1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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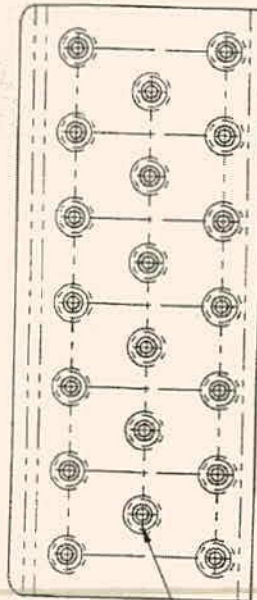
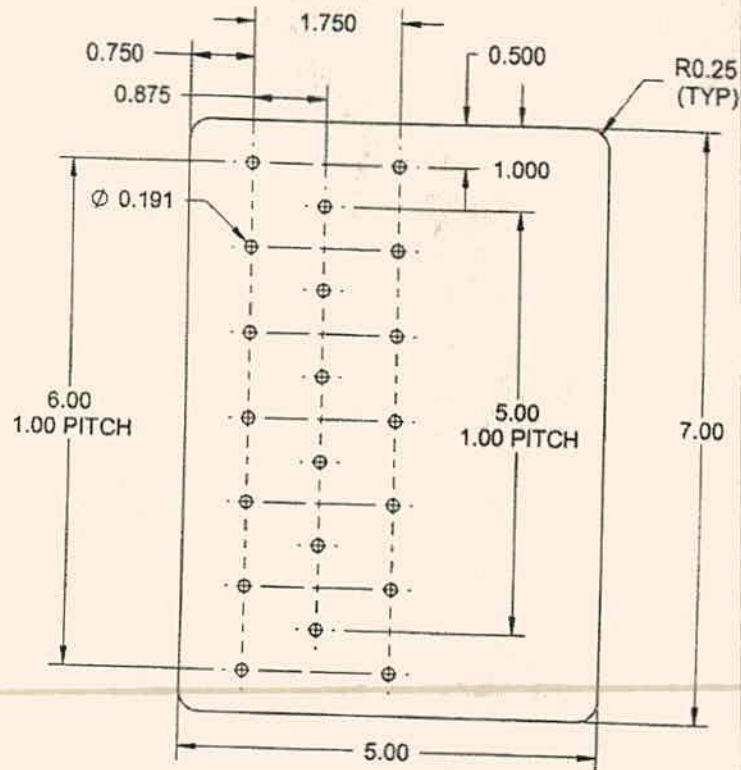
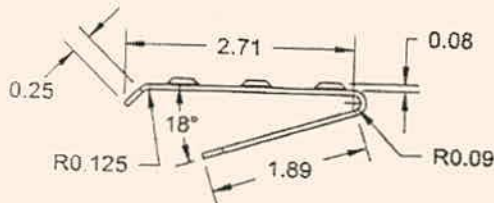
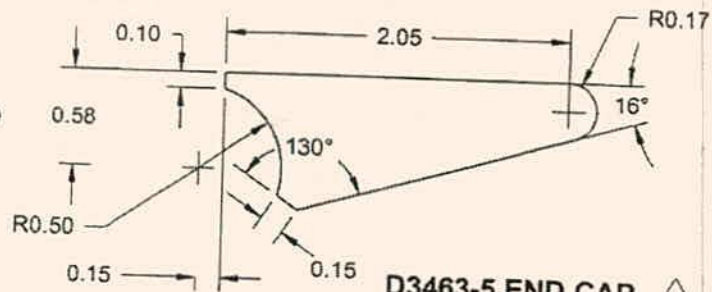
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DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B
DATE 05.12.05		TITLE STEP WELDMENT	SHEET 4 OF 4
			SCALE 1:2

**RELEASED**

05.12.05 #

FORM USING  
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**  
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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